

# Work Order ID 102576

June-03-13 10:07:30 AM

\*102576\*

Page 1

Item ID: D2535

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Spring

Stop \*NS2\*

Start Date: 6/03/13

Start Qty: 30.00

Required Date: 6/10/13

Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 13-06-03

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2535	Rev A								
100	PURCHASING	0.00							
*100*									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>20006</u> Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
*110*									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
*120*									
QC	Memo	0.00							
Quality Control	Check dims to dwg								

CL 13/06/03 SO

P43/6/27 (50)

SO

Shp  
B62J

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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# Work Order ID 102576

June-03-13 10:07:30 AM

**\*102576\***

Page 2

Item ID: D2535

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Spring

Stop **\*NS2\***

Start Date: 6/03/13 Start Qty: 30.00

**\*30\***

Cust Item ID:

Required Date: 6/10/13 Req'd Qty: 30.00

**\*30\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: STC11

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

50x 11.11.13-06-27

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

11.5 13-06-28

11 13-06-28

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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June-03-13 10:07:37 AM

Page 1

**\*102576\***

**\*D2535\***

**Required Date:** 6/10/13

**Required Qty: 30.00**

**Comments:** IPP A99.04.19New Issue (From hand written IPP)DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2535P		Purchased	No			100	Each	0.0000	1	<del>30</del>			
*D2535P*									**	30		10/13/12	50
Spring													

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Material									
Operator									
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Process									
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Training									
Transport									
Unapproved									

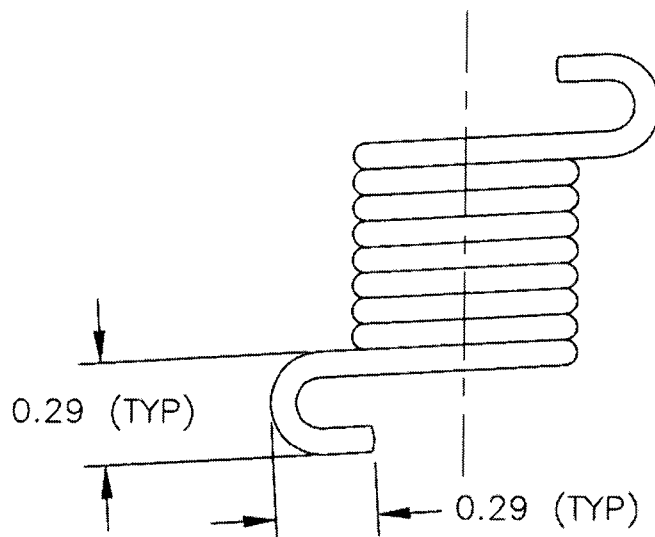
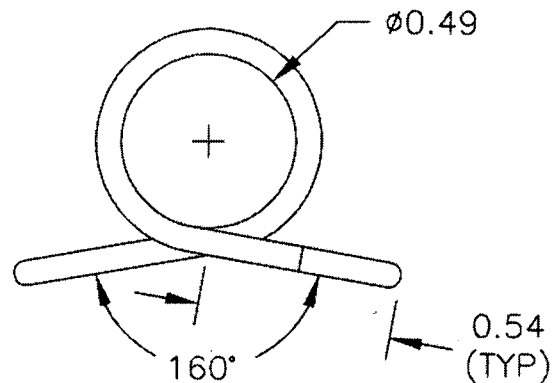
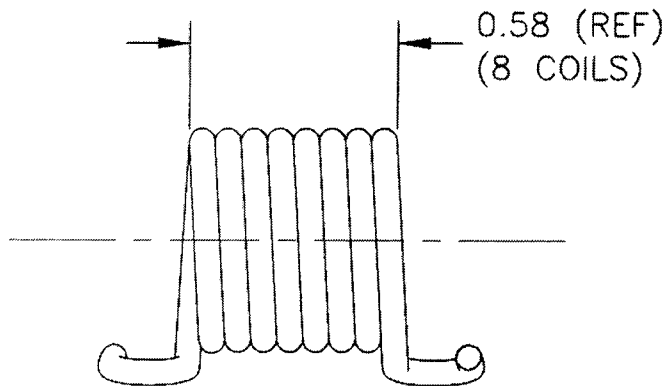
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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED  
99.05.11 KE



SUPPLY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AGREEMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 102576 MJS  
13-06-03

#### SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL  $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO20066**

Purchase Order Date 6/3/2013

PO Print Date 6/3/2013

Page Number 1 of 1

Order From :

VC-VIC002

VICTORY SPRING LTD.  
#2 6104 - 82 AVE.  
EDMONTON, AB T6B 0E7  
CA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

866 230 5312

Requisition Nbr

Vendor Fax

866 230 5338

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
6/13/2013

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2535P	Spring	6/14/2013 Yes	50.00 Each	FedEx PI collect	\$4.5600	\$228.00

Special Inst: AS PER DWG D2535 REV. A  
B102576

PO Total:

\$228.00

W CL

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required **YES** NO

Change Nbr: 1

Change Date: 6/3/2013



**INVOICE** 27213

#2, 6104 - 82 Ave  
Edmonton, AB T6B 0E7  
t + 780 442 4020  
f + 780 466 8000

**BILL TO:** Dart Aerospace Ltd  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

**SHIP TO:** Dart Aerospace Ltd  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7

DATE		ORDER No.		SHIP VIA	
Jun 03, 2013		PO20066			
QUANTITY	DESCRIPTION			UNIT	AMOUNT
50	VIC 1533 D2535P Spring - Torsion			4.56	228.00
E-MAILED					
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS	228.00	0.00	11.40	239.40

## CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace	DATE: 6/3/2013
PART/DRAWING #: D2535P	PO # PO20066
DESCR: Torsion Spring	QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	Yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	0.491	
Coil O.D.			
Number of Coils	8 ref	yes	
Free Length			
End Type	per dwg	Yes	
Helix	RHW	yes	

### COMMENTS

Mill Certificate attached: no  
Material Heat Number: 35791

Inspected by: *Chris Burrowes*